

Date: Wednesday, 3/7/2007 2:22:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number	: 31046		
Estimate Number	: 10800		
P.O. Number	: <i>N/A</i>	Part Number	: D350600141
This Issue	: 3/7/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3188,ICA
First Issue	: 3/7/2007	Project Number	: <i>N/A</i>
Previous Run	: 30623	Drawing Revision	: C
		Material	: <i>N/A</i>
		Due Date	: 3/30/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev D 05.04.14 Incorporated procedures from D3187-1/2 K J/JLM Est Rev:E 06-11-20 As per DSI9335 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



new paperwork / loads
KS 07.03.16

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

2.0

31046A

SWITCH RELOCATION KIT



D350-600-349 B P 33901A

Comment: Sub-Component SWITCH RELOCATION KIT

3.0

31046B

30081

SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: *B 30081*

ml 07/08/07

4.0

31046C

*31046C*

SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-1 B *30076* *31046C*

ml 07/08/07

5.0

D31871

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3187-1

Floor *B25404* ✓

1 D3186-1

Door (ref) *B31046C*

1 D3188-1

Body (ref) *B30081*

ml 07/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

28 ALS4-1032-130

Insert

M103495 -

Handwritten signature and date 07/08/07

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

Handwritten date 07/08/08 x1

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten date 07/08/08

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

Handwritten date 07 08 09

Handwritten circled G

10.0

POWDER COATING

POWDER COATING



Handwritten M102316



Handwritten circled X

Comment: POWDER COATING

*****D3187-1 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Handwritten date 07/08/10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten date 07/08/10

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

n/A ml 07/08/16

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

5.62SF D2986

Neoprene Foam

B30632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch: M102565

ml 07/08/16

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

on 07/08/16

16.0

ALS41032130

Insert

AN 3235-020-935



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Insert

batch:

Washer x8

B M 104760

PTO

17.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DECAL

batch:

B31127

18.0

MS20426AD45

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Batch:

M3456

EP 07/08/070

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/08/07	16	This step should be AN 3235 - 020 - 935 batch: _____	BE	07.08.07		140828	140828	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/09/05
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

D35491

BRACKET



[Handwritten signature]



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
BRACKET
batch: B31125

20.0

D2237

Striker Plate



[Handwritten signature]



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Pick:
Batch: B31692

21.0

D35547

BALL STUD



[Handwritten signature]



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
BALL STUD
batch: B30210

22.0

AN960JD516

Washer



[Handwritten signature]



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:
Batch: M104156

23.0

D30153

Lock Nut



[Handwritten signature]



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:
Batch: B33423

24.0

MS20426AD46

Rivet



[Handwritten signature]



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Rivet
Batch: M100151

25.0

D35381

HINGE BRACKET



[Handwritten signature]



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
HINGE BRACKET
batch: B3237m1

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
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Job Number: 31046

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2179

Doubler



Handwritten signature



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B30630 -

27.0

AN526C832R14

Screw



Handwritten signature



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M9216 -

28.0

AN960JD8

Washer



Handwritten signature



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104537 -

29.0

MS21042L08

Nut



Handwritten signature



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M104812 -

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Handwritten mark



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for body & floor*

N/A mlo 07/08/14

31.0

D35529

CARBON STEEL GAS SPRING



Handwritten signature



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30673 -

32.0

MS270390811

Screw



Handwritten signature



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585 -

07/08/070

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31046

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description:

33.0

AN960JD8

Washer



EP



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Washer
batch: M104537

34.0

NAS1515H3

Washer



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Washer
batch: M100993

35.0

MS21042L08

Nut



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Nut
batch: M104812

36.0

D2464

3/4 Seal



EP



Comment: Qty.: 11.3400 f(s)/Unit Total: 11.3400 f(s)
3/4 Seal
Cut 127.00" long batch: B30681

37.0

D35671

DECAL



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
DECAL
batch: B31127

38.0

D2586

Door Latch



EP



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Door Latch
batch: B32504

39.0

D2585

Latch Clamp



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) 3X
Latch Clamp
batch: B33487 X3

ml EP 07/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31046

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D2621

Latch Plate



JP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Latch Plate

batch: B28916

41.0

MS27039115

Screw



JP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Screw

batch: M105108

42.0

AN960JD10

Washer



JP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

batch: M104885

43.0

MS21042L3

Nut



JP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

batch: M104547

44.0

D28571

Hinge Bracket



JP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B31832

45.0

D2228

Backing Plate



JP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Backing Plate

batch: B30679

46.0

AN526C832R10

Screw



JP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104603

JP 02/08/070

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31046

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



EP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M104537

48.0

MS21042L08

Nut



EP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M104812

49.0

D28572

Hinge Bracket



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B30718

50.0

D35481

BRACKET



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: 30245

51.0

D35547

BALL STUD



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210

52.0

AN960JD516

Washer



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M104156

53.0

D30153

Lock Nut



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B33423

EP 7/68/670

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 31046

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

ml 07/08/24 *X1*

55.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-28-20 *(V)*

56.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: *m 105386*

BK

07-08-30

(P)

57.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M-A

07/08/30 *(IX)*

58.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1- K10018

Spacepod Hardware Kit

D31805
B25404

1 D3187-1(Ref)

Spacepod Floor

07/08/30

59.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/08/30 +

60.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev: *D*

07/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/09/05
 QA: N/C Closed: _____ Date: _____

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Job Number: 31046

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Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

207109/05

Job Completion



61-0905

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
JB		LE		HAMKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
DATE		TITLE		SHEET 1 OF 11	
06.12.13		SPACEPOD BODY		SCALE	
A		03.04.03		NEW ISSUE	
B		06.10.06		UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C		06.12.13		REMOVED D0600-XXX LABELS	

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES

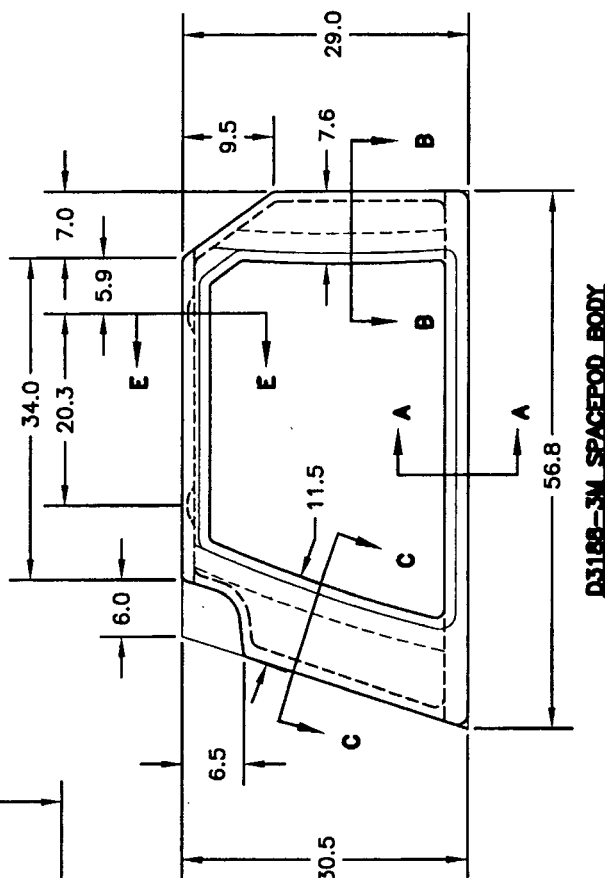
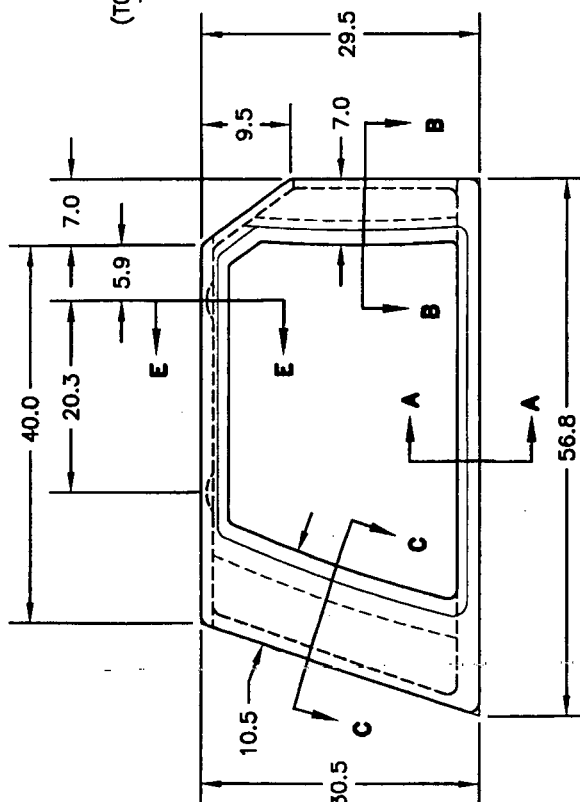
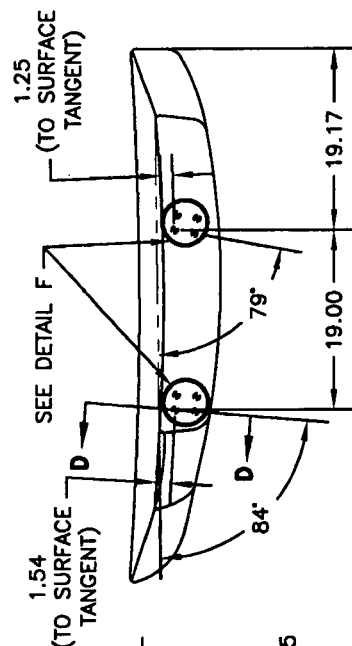
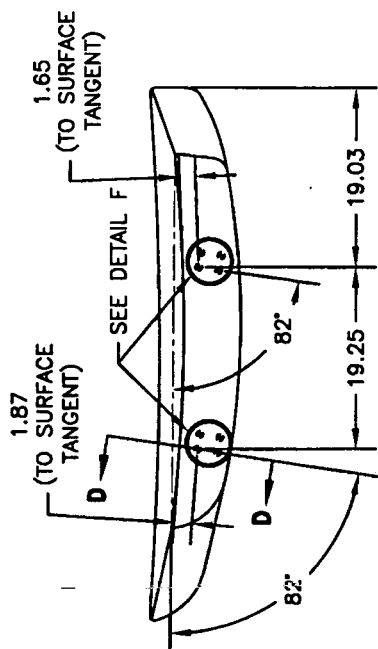
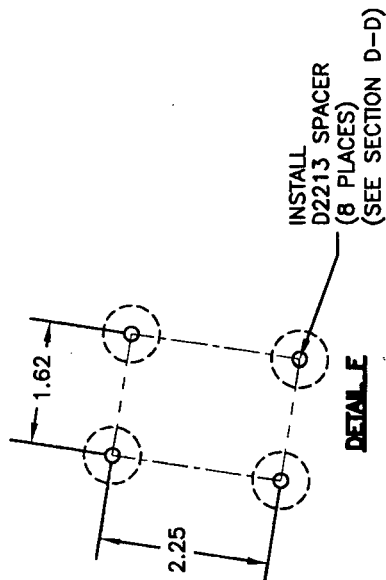
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06.12.22

NO. 31046
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 2 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-1M SPACEPOD BODY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **31046**

RELEASED
06-12-22

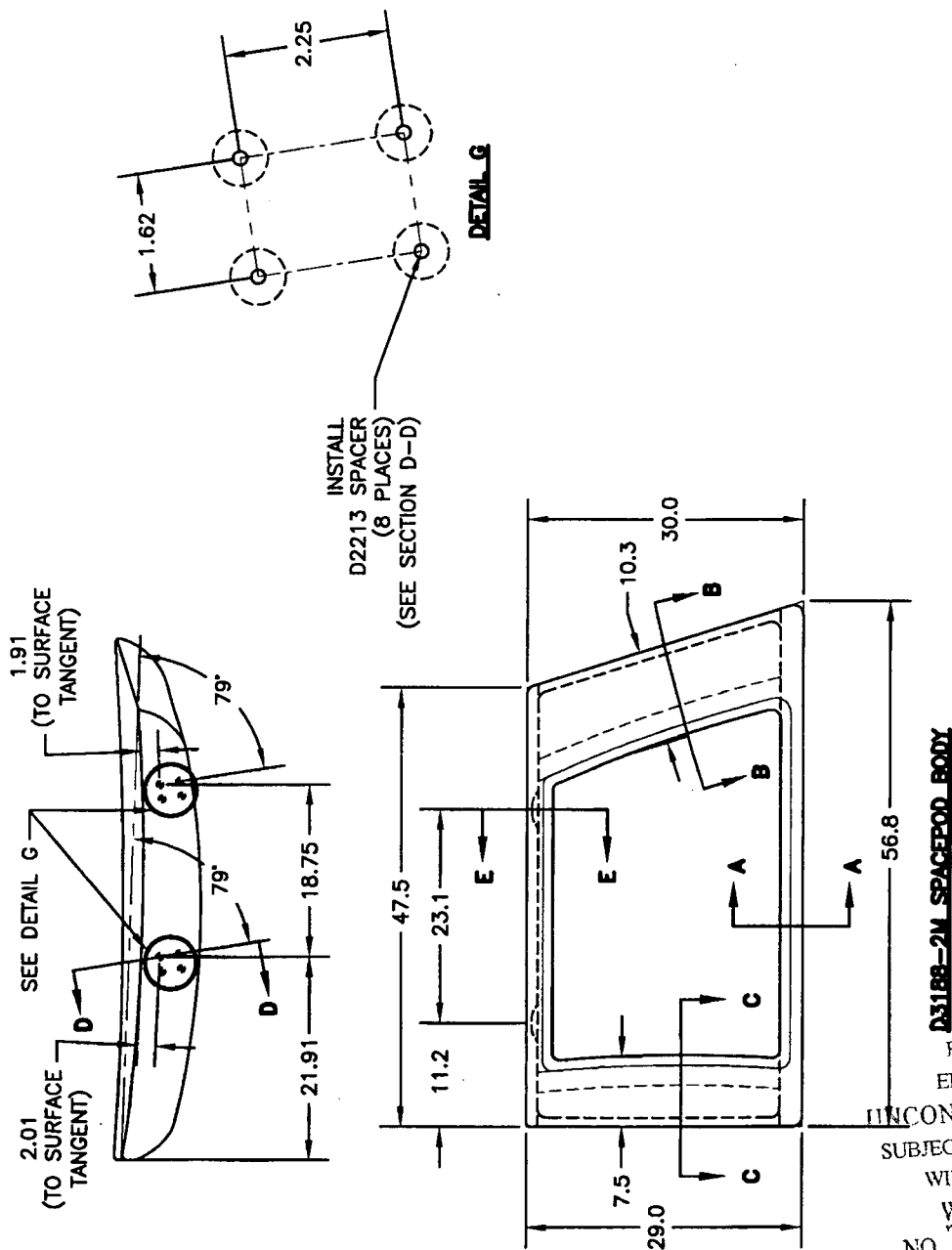
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-2M SPACEPOD BODY

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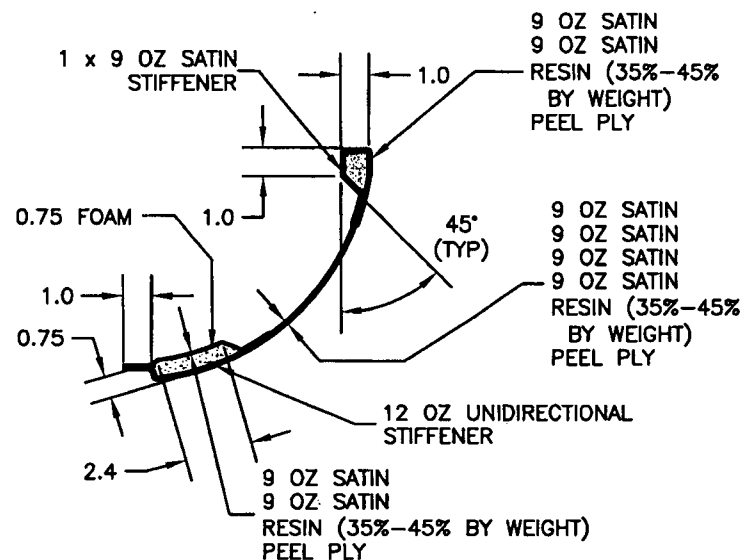
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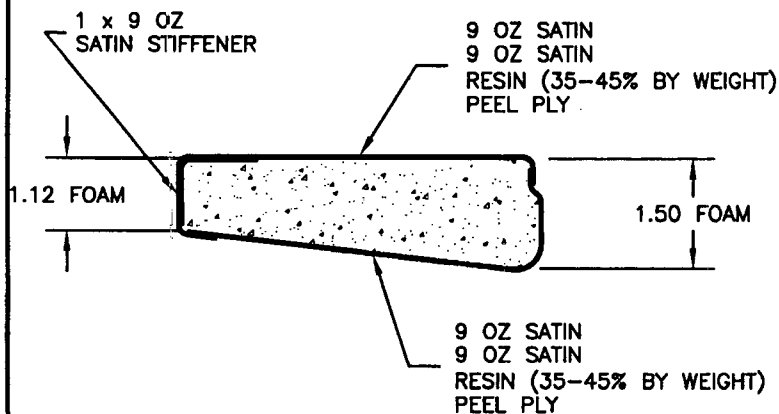
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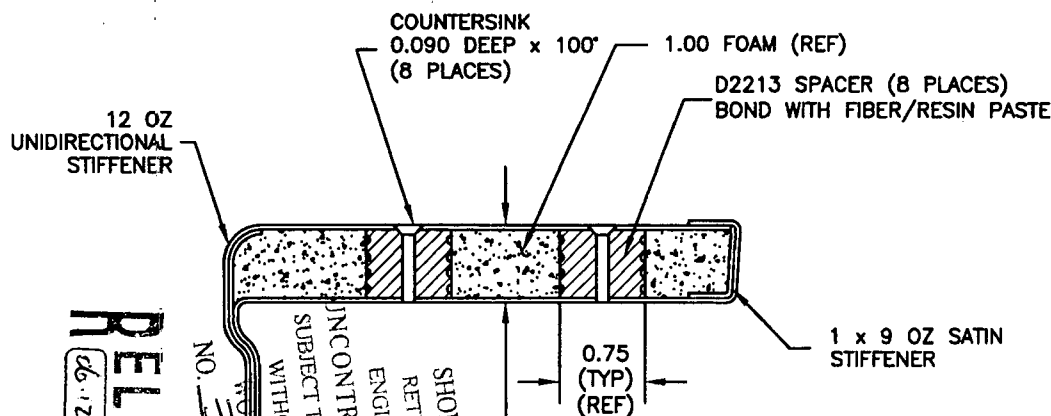
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TITLE	SPACEPOD BODY	SHEET	4 OF 11	SCALE
				NTS



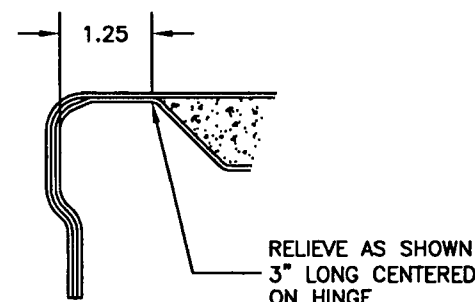
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

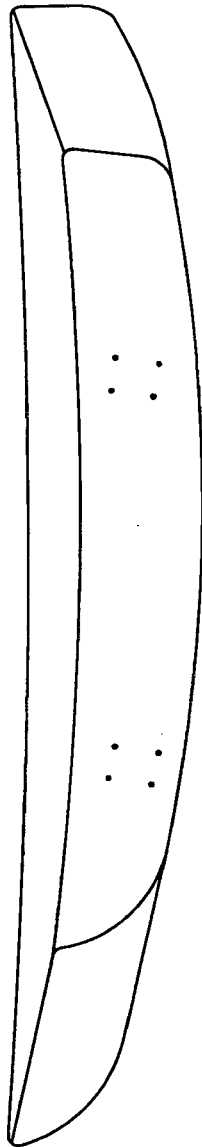
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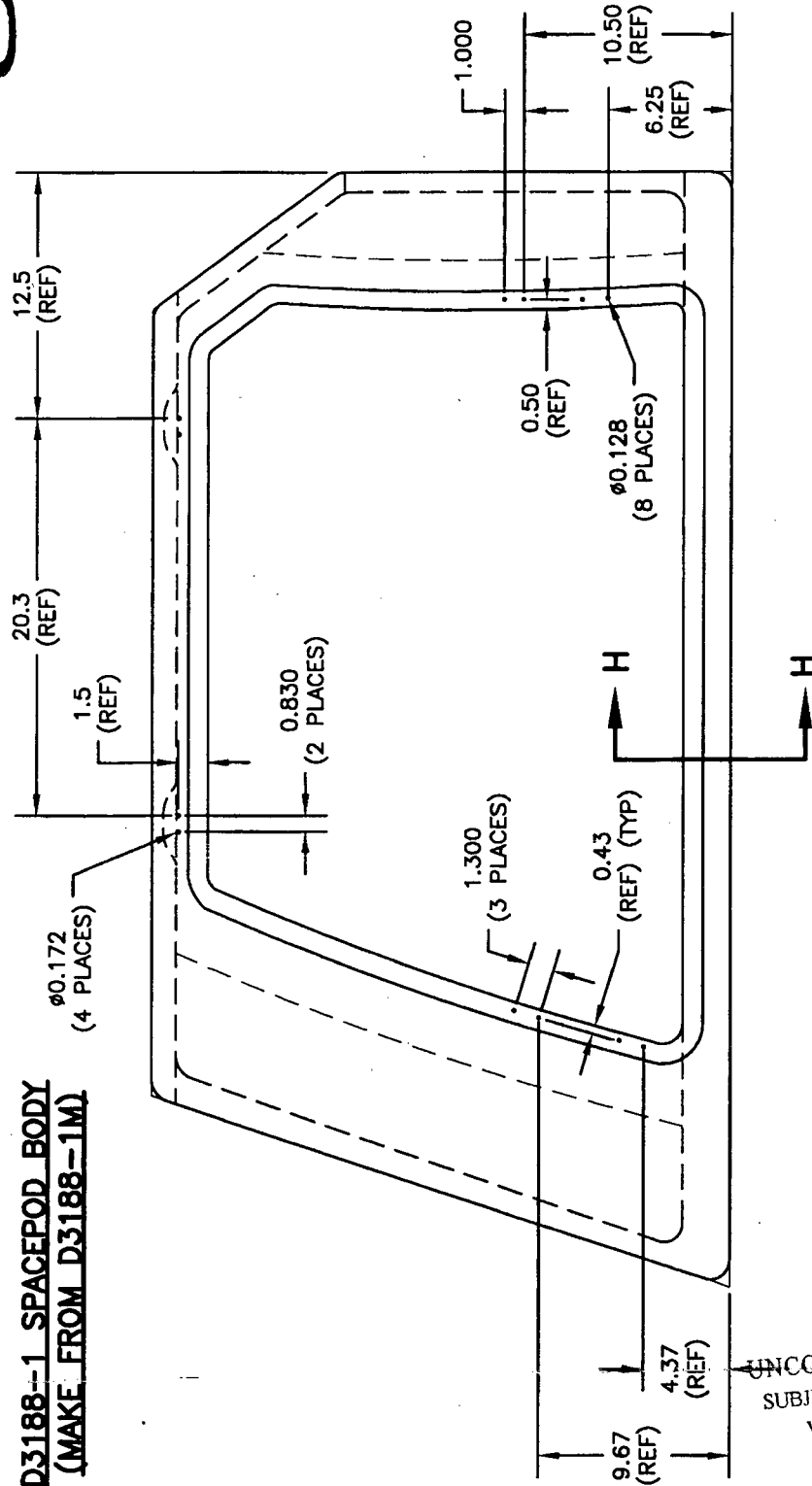


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**D3188--1 SPACEPOD BODY
(MAKE FROM D3188--1M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186--1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

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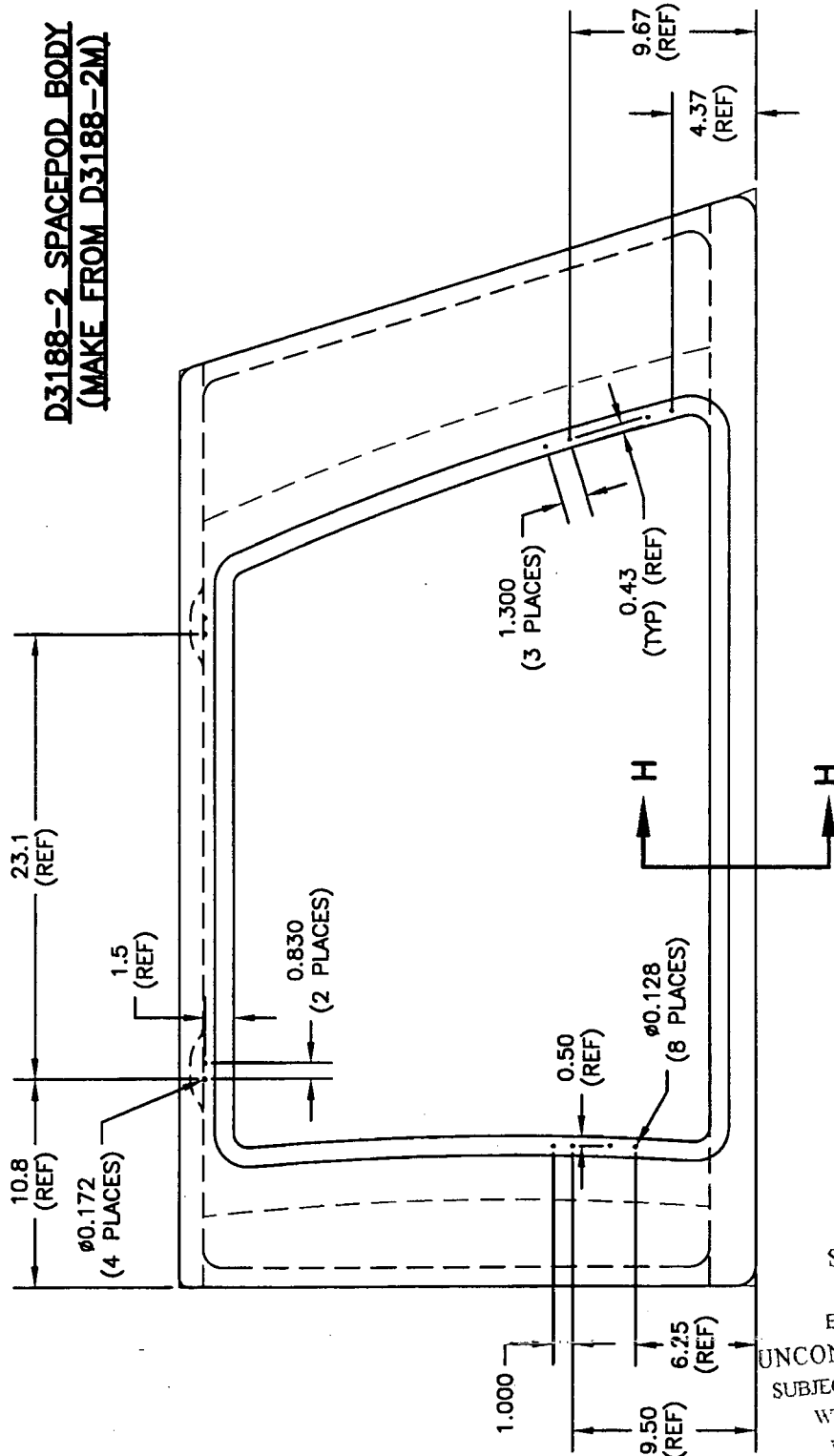
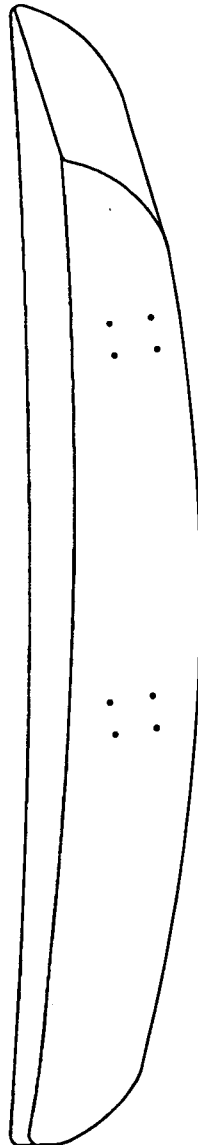
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**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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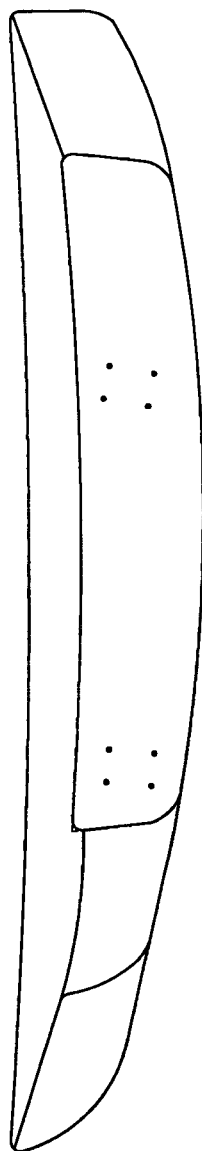
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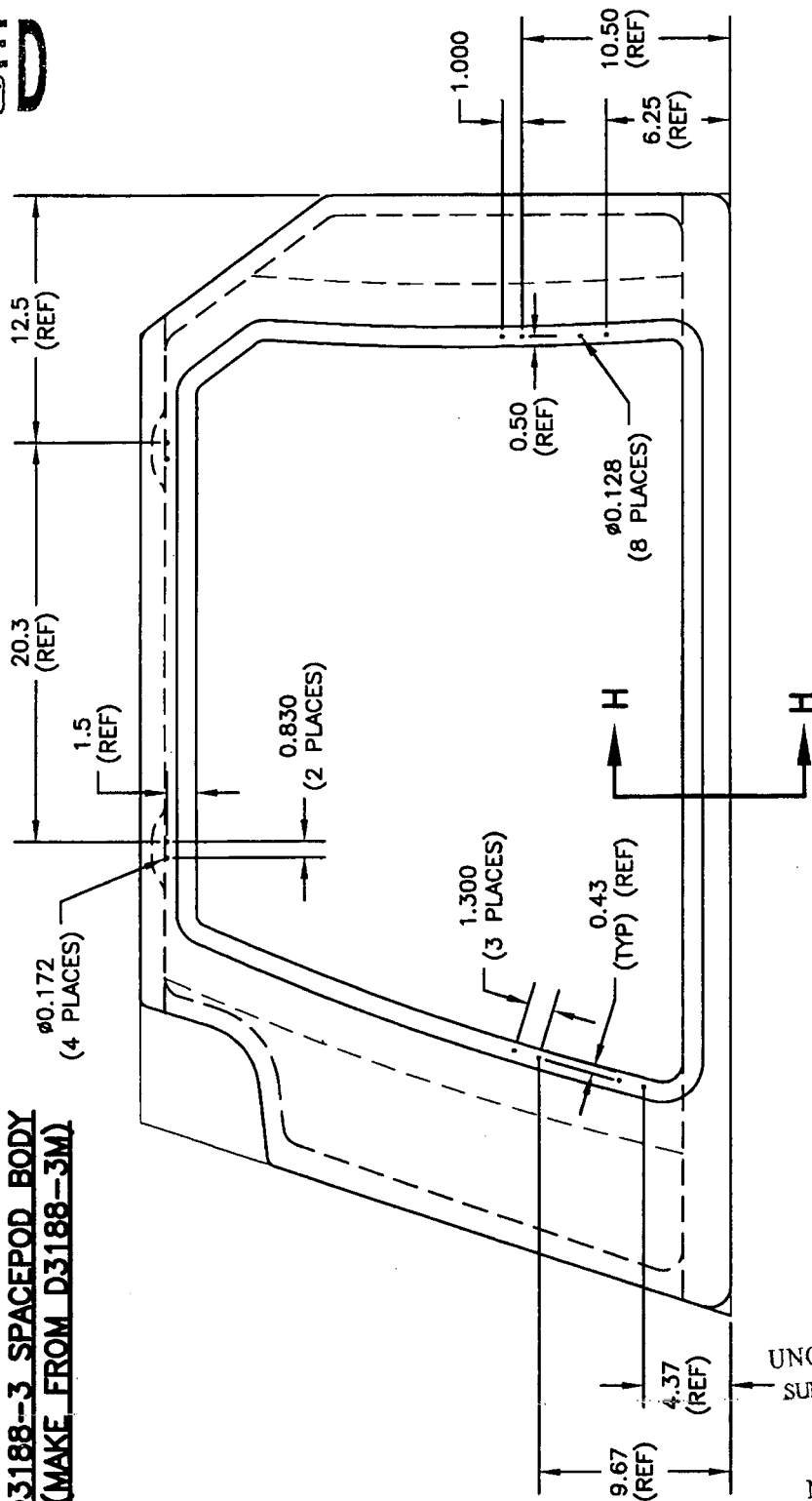


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**D3188--3 SPACEPOD BODY
(MAKE FROM D3188--3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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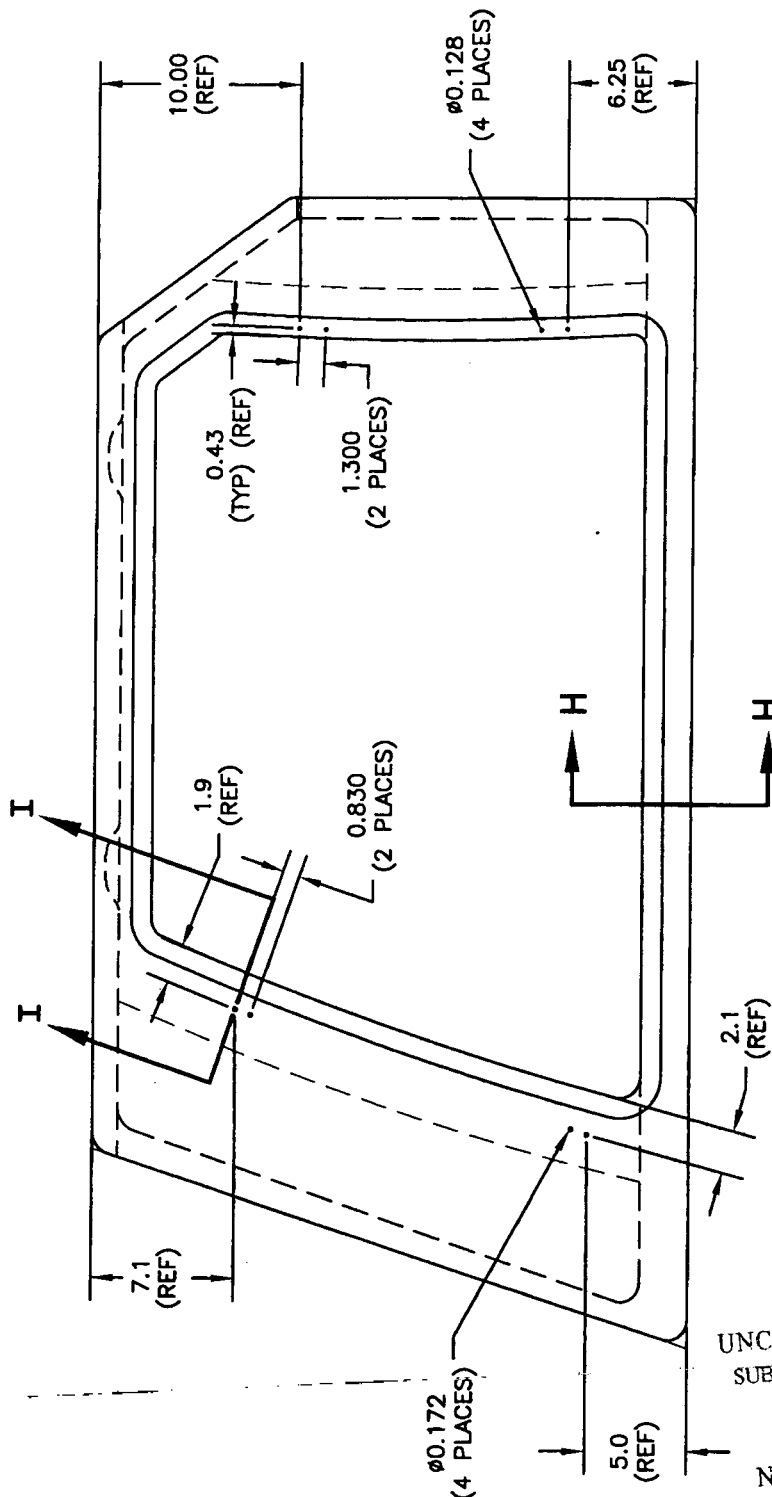
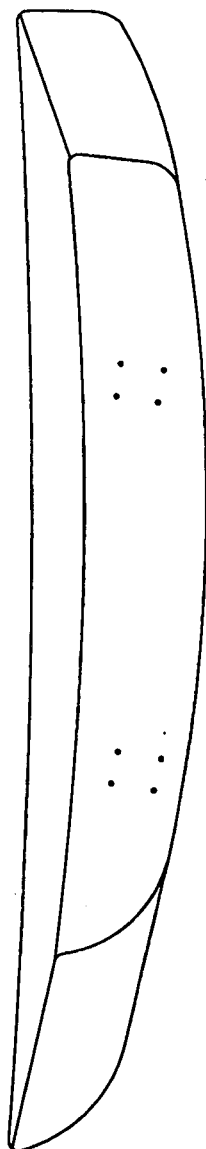
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D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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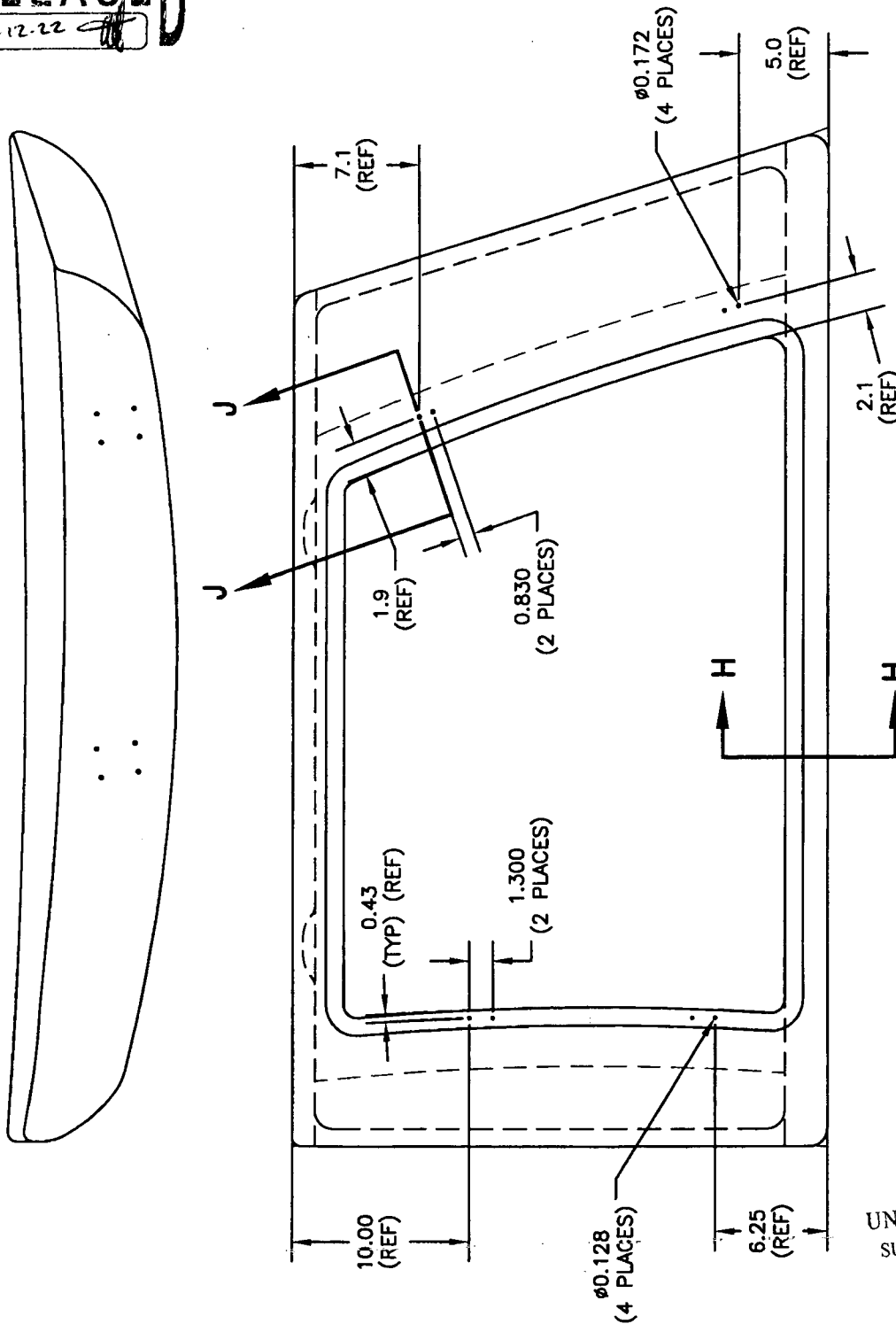
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D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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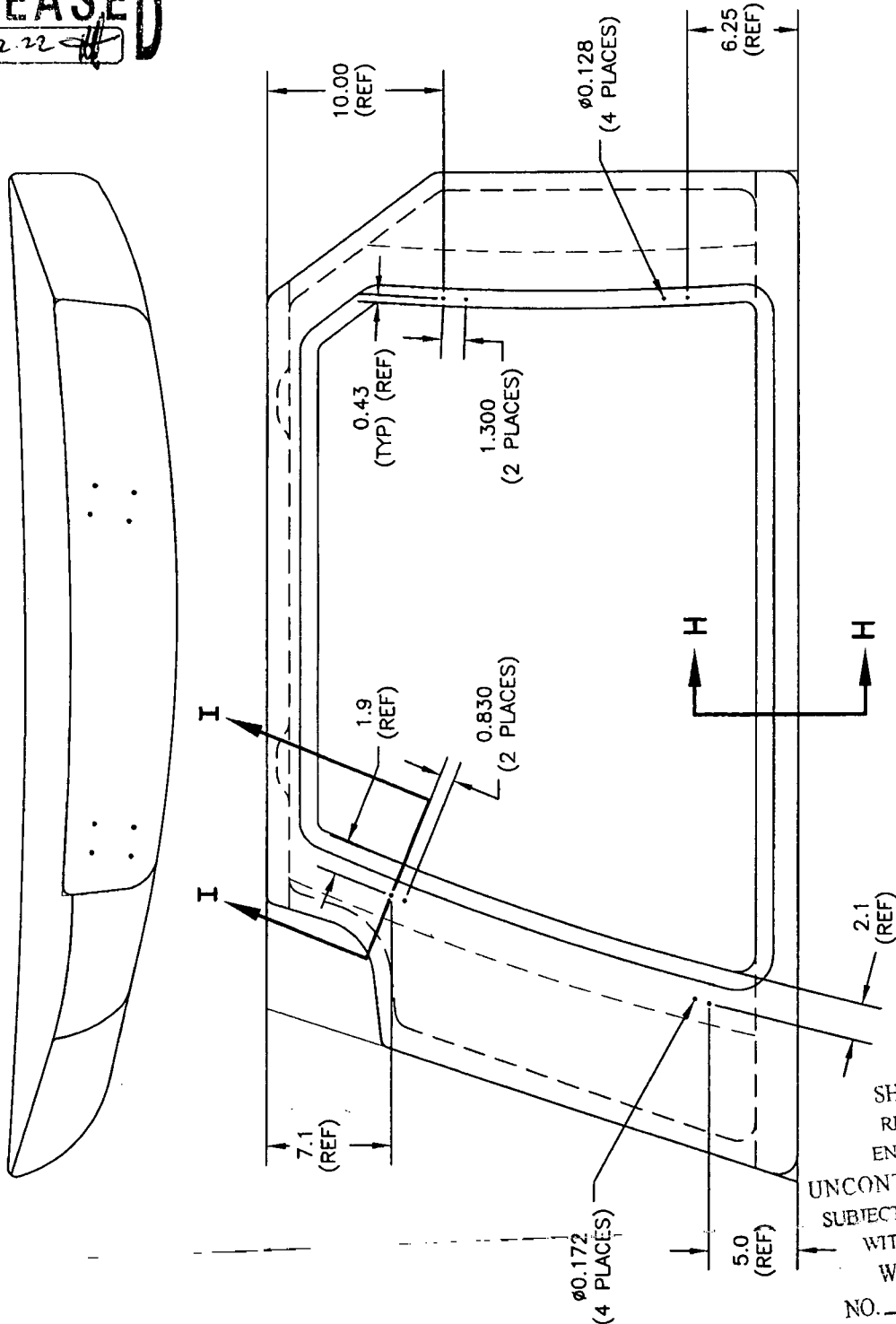
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D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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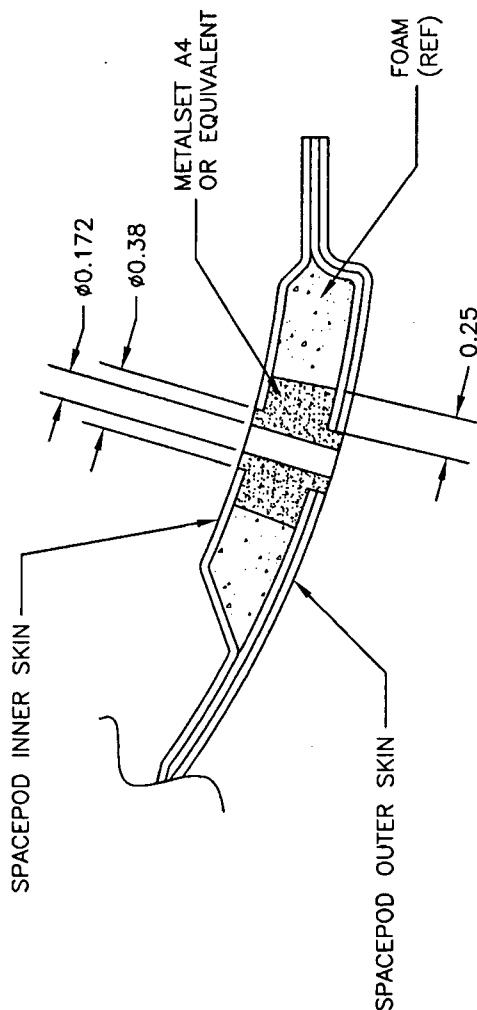
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INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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